Work Orde Wednesday, Augu												Page 1
Revision ID:	D3536-35 Gasket		A	ccept				s s	etup	Start Stop		
Start Date: Required Date: Reference:	9/1/2011 9/15/2011	Start Qty: 16.00 Req'd Qty: 16.00	1.00.00 (10.0 0)		Cust Item I Customer:	D:						
Approvals:		n: MF		Tooling: SPC (Y/N):		ite:		R	lun	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3536	Rev	A										
100 	t	FLOW WATER JET Memo I-Cut as p Deburr if r	er Dwg D3536 □Dwg Rev:_ necessary	0.00 0.00 A SProg Rev.	A.' [22-			IDI.	(<u>- 9</u> -	P6	· 9	54
110 		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				t\$.	(~ <u>9</u>	-39		
120		OC8- Inspect parts - se	cond check	0.00								

0.00 S world

Memo

Quality Control

	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Yes	No DQ	A :	Date:	
	R	esolution:	Disposit	ion:	QA: N/C C	osed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date	Secu	ion C	Chile Eng	QC Inspector
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					:				

Work Order ID 73313

Wednesday, August 31, 2011 10:49:33 AM



Page 2

Item ID:

D3536-35

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 9/15/2011

Gasket

9/1/2011

Start Qty: 16.00

Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:

Date:

Run

Start Stop

Stop

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

0.00

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:			WO	RK ORDER CHANGE	ES				
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Part No);	PAR #:	Fault Cated	gory:	NCR: Yes	No DQ	A:	Date: _	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	tion C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, August 31, 2011 10:49:30 AM

Work Order ID: 73313

D3536-35 Parent Item:

Parent Item Name: Gasket

Start Date: 9/1/2011

Required Date: 9/15/2011

Page 1

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	583.5500		11.01689	14.		
NEOPRENE SHEET 0.063										B(L	-9-29		

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code
MAT052	583.55	
117295	55.68	
118026	127.87	
118663	400	

W/O:			- 10 19 19 19 19 19 19 19 19 19 19 19 19 19	WORK ORDER (CHANGES					
DATE	STEP		PRO	OCEDURE CHANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		i			·					
Part No):		PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Annroyal					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

DART AEROSPACE LTD	Work Order:	733/3
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030			,,,		
		93.92	>		Thon	
19.75	+/-0.030	1475	∞		7	
17.75	+/-0.030	17-75	2		7	·
14.25	+/-0.030	14.25	2		T	
9.50	+/-0.030	9.50	>		7	
4.75	+/-0.030	4,75	_		T	
2.00	+/-0.030	00. C	0		7	
6.00	+/-0.030	6.00	7		T	
6.75	+/-0.030	6.75	8		7	
0.30	+/-0.030	•363	¥		V BUZ	
0.30	+/-0.030	, 304	2		ν	
1.89	+/-0.030	1,989	8		V	
Ø0.19	+0.005/-0.001	1,193	>		V	
0.063	+/-0.010	.062	>		V	

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-9-29	Date: 11/08/29	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	07.03.14	New Issue	KJ/JLM A	Cid
			70	7~/

Dart Aerospace Ltd	Da	art	Aer	OSI	pace	Ltd
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W/O:			W	ORK ORDER CHA	ANGES							
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			-									
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DATE	STED	Description of NC			Section B	on B Sign &		ication	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng		Date	Sec	tion C	Chief Eng	QC Inspector		
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DART

AEROSPACE PORT HADLOCK,

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REV.

USA,

NC.

06.10.25

GASKET

D3536 DRAWING NO

06.10.25

NEW ISSUE

26.65 23.15 17.65 13.40 -0.90 - 5.65 -1.89 3.90 DETAIL A ø0.19 (TYP 3 PLS)

D3536-11 GASKET

A. 62.12

-	32.90
 	29.40
	27.40
-	23.90
	18.98
Q DETAIL A #0.19 (TYP 4 PLS)	14.07 9.15 0.90 1.89 8.00 3.90

D3536-13 GASKET

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PURPOSE

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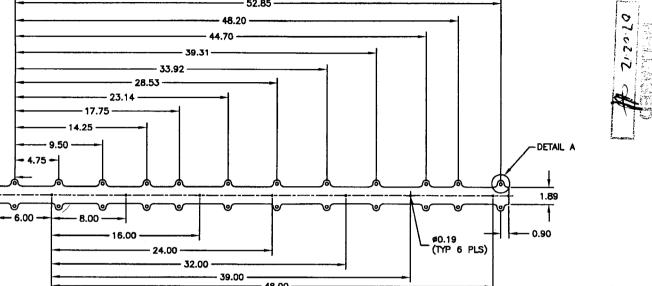
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dail Aciospace Lia	Dart	Aeros	pace	Ltd
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	pace										
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			ection C	Chief Eng	QC Inspector		
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		Section A						Chief Eng	QC inspector
		Section A						Chief Eng	QC inspector
		Section A						Chief Eng	QC inspector
		Section A						Chief Eng	QC inspector
		Section A						Chief Eng	QC inspector
		Section A						Chief Eng	QC inspector
		Section A						Chief Eng	QC inspector



52.85 48.20 44.70 39.31 28.53 	DART
D3536-23 GASKET	CHECKED AP DATE 06.10.25
1.45 1.45 16.35 1.45 16.35 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE	APPROVED DRAWING NO. D3536 TITLE GASKET
3) PART IS SYMMETRICAL ABOUT © 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) ALL DIMENSIONS ARE IN INCHES 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION D3536-25 GASKET	PORT HADLOCK, WA REV. A SHEET 3 OF 6 SCALE

Dart	Aeros	pace	Ltd

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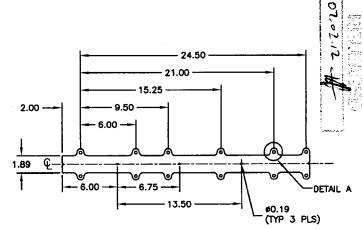
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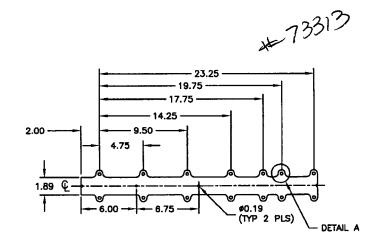
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22.50 19.00 14.25 2.00 -6.00 --**Q**-1.89 - 6.00 #0.19 (TYP 3 PLS) D3536-31 GASKET

DETAIL A



D3536-33 GASKET



D3536-35 GASKET

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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
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 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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				Corrective Actio	n Section B		1,4 :4:			Ι

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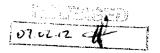
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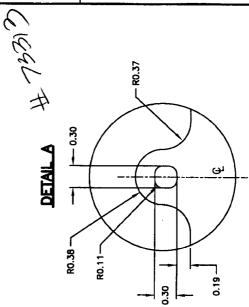
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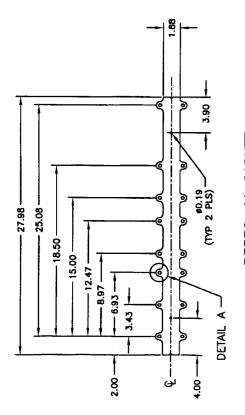
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DATE		TITLE	SCALE
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M—NEO60—S.063) FINISH: NONE
PART IS SYMMETRICAL ABOUT ©
TOLERANCES ARE PER DART QSI 018 UNLESS
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IDENTIFY WITH DART P/N USING A WHITE FINE POINT
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